

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007639**Date Inspected:** 08-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan

CWI Name:	Pin-Tang Hsu		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A
Component:	Tower, Jacking and Deviation Saddles	

Bridge No: 34-0006**Summary of Items Observed:**

On this date, 7/08/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections in Foundry and associated built up plate sections in the Fabrication shop #4 at Japan Steel Works (JSW), Muroran, Japan.

WEST DEVIATION SADDLES

W2E3 - Saddle has been located in Machine Shop 2 undergoing final machining.

W2W2 - Second shift welder M.Kato 08-5018 is welding joint W2Y-17U-2 with FCAW process and procedure SJ-3011-7 using SMAW 5mm E7016 electrode. Mr. Pin-Tang Hsu, QC CWI monitors parameters on a random basis.

TOWER SADDLES

T1-2 - Stiffeners are completely welded in and contour grinding has commenced to profile the welds.

T1-3 - See below conversation held with QC CWI Mr. Chung Fu Kuan. Base plate, 9-4, was being welded by two individuals, R.Iizuka 06-2643 and M.Kubota 74-3666, both were welding joint 9Y-6L. Procedure in use was SJ-3012-2, SMAW, 5mm E7016 electrode, in Fabrication Shop #4. By the end of this QA Inspector's shift, the Tower saddle section begins relocation.

EAST SADDLES

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

E2E1 - Cast section is now under preheat and per JSW representative, Mr. Hideaki Kon, repair welding will commence tomorrow morning (9 July 2009).

E2W1 - Casting awaits blast cleaning to prepare repair areas for NDE, in Foundry.

West Jacking Saddle - Cast Section is being ground by hand held power grinders by one individual in the Foundry, approximately 10% complete.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

QA Inspector, Mr. Mike Brcic, while touring spaces, was approached by QC CWI Mr. Chung Fu Kuan with information regarding Plate 9-9, of Tower Saddle T1-3. The outboard edge of the plate had been cut shy of required dimension during its original cut. The intention of JSW is to submit an ECS to receive approval to build up the area with weld material, per Bridge Welding code, AWS D1.5 2002, paragraph 3.7.4.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
